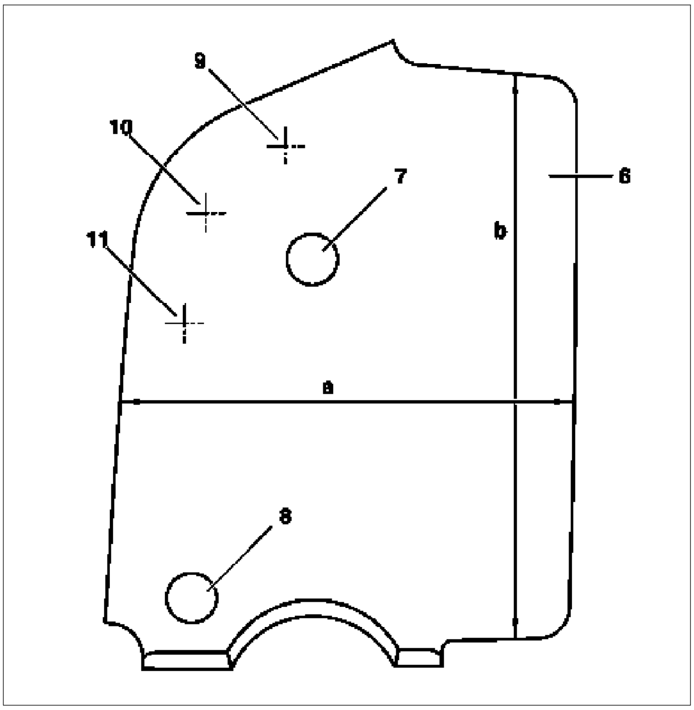
**MODELS 163.136 /154 /172 #A as of 145273,**
**163.136 /154 /172 #X as of 708319,**
**163.113 /128 /174 /175**

**The template shown is for the left side**
**(turn over for the right side)**

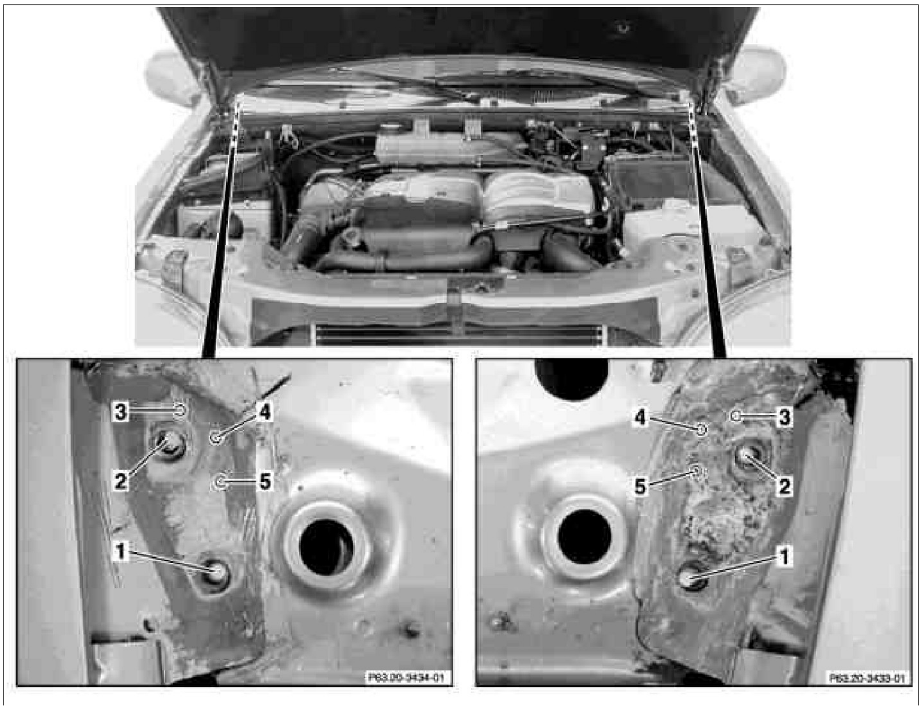
*6 Template*
*7 Hole, hinge assembly bolt, rear*
*8 Hole, hinge assembly bolt, front*
*9 Center punch position*
*10 Center punch position*
*11 Center punch position*

*a 80 mm*
*b 100 mm*




P63.20-3439-12

*1 Hinge assembly bolt, front*
*2 Hinge assembly bolt, rear*
*3 Center punch mark*
*4 Center punch mark*
*5 Center punch mark*



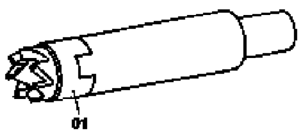

P63.20-3435-06

**Operation no. of operation texts or standard texts and flat rates**

| Range | Op. no. | Operation text | Time | Acc. no. | Code |
|---|---|---|---|---|---|
| P | 023540 | REINFORCE LEFT ENGINE HOOD HINGE SUPPORT | 037 WU/3.1 hrs. | 88 237 36 | --- |
| P | 023541 | REINFORCE RIGHT ENGINE HOOD HINGE SUPPORT | 040 WU/3.3 hrs. | 88 237 36 | --- |
| P | 023542 | REINFORCE (BOTH) ENGINE HOOD HINGE SUPPORTS | 053 WU/4.4 hrs. | 88 237 36 | --- |

| | **Remove/install** | | |
|---|---|---|---|
| 1 | Ensure that the recirculated air function is deactivated | | |
| 2 | Remove engine hood | | AR88.40-P-3000GH |

| | | | |
|---|---|---|---|
| 3 | Remove engine hood hinge on the front passenger side | | AR88.40-P-3060GH<br><br>*BR00.45-Z-1004-01A |
| ⚠ **Danger!**<br><br>4 | **Risk of explosion** from explosive gas. **Risk of poisoning and caustic burns** from swallowing battery electrolyte. **Risk of injury** through burns to skin and eyes from battery acid or when handling damaged lead-acid batteries<br>Remove battery | No fire, sparks, naked flames or smoking.<br>Wear protective gloves, acid-resistant clothing and safety glasses. Pour battery electrolyte only into suitable and appropriately marked containers. | AS54.10-Z-0001-01A<br><br>AR54.10-P-0005GH |
| 5 | Remove air conditioning blower motor | | AR83.30-P-5560GH |
| 6 | Print out template (6) and adapt the size to the correct dimensions (a, b) | Determine ACTUAL dimension (a) from the drawing.<br>Divide the SPECIFIED dimension (a) by the determined ACTUAL dimension (a) and copy the template to the original size with the corresponding factor.<br>Check dimensions for both axles. | |
| 7 | Cut out template | | |
| 8 | Cut out holes (7, 8) for engine hood hinge studs | | |
| 9 | Position template in the engine hood hinge support using the stud holes | The template is drawn for the left side. Turn over to obtain the right side. | |
| 10 | Center the engine hood hinge support on the template using the markings (9, 10, 11) | | |
| 11 | Remove template | | |
| 12 | Drill a hole at each center punch mark (3, 4, 5) | Only drill through the 2 upper panels. Do not drill through the reinforcement panel (3rd panel). | *201589005100 |
| 13<br><br>C | Cover windshield, paint surface and adjacent components adequately in order to avoid damage due to welding work<br>General information on repairs to body | Cover apertures in the body in order to prevent flying sparks: the foam in the instrument panel burns easily. | AH60.00-N-0001-01A |
| ⚠ **Danger!**<br><br>14 | **The high voltage used for arc welding presents a lethal hazard**. **Explosion hazard** when welding in area of materials easily inflammable. **Injury hazard** from welding spatter and UV-light while welding. **Risk of poisoning** when inhaling welding vapors.<br>Plug weld each hole | Use insulating mats. Wear protective clothing, safety glasses, and protective mask. Remove highly inflammable materials from the danger zone. Use air extractor. | AS00.00-Z-0007-01A<br><br>*WE58.40-Z-1005-02A |
| 15 | Plug welds should be flat and ground smooth | | |
| 16 | Remove covers and clean the repair area | | |
| 17 | Prime untreated points in the area of the engine hood hinge support | | |
| 18 | Prime the underside of the reinforcement panel of the engine hood hinge | Access to underside of engine hood hinge support through the recess for the wiper motor. | |
| 19 | Spray the underside of the reinforcement panel of the engine hood hinge support with wax preservative | Access to underside of engine hood hinge support through the recess for the wiper motor. | |
| 20 | Install in the reverse order | | |




201 589 00 51 00

Weld spot miller

**Workshop equipment/MB testers** (see Workshop Equipment Manual)

| | |
|---|---|
| WE58.40-Z-1005-02A | MIG inert gas welding equipment, aluminum weldable, sold by company Wieländer & Schill |

**Repair products**

| Number | Designation | Order number |
|---|---|---|
| BR00.45-Z-1004-01A | MB body sealant for sealing seams (suitable for painting) | 001 989 63 20 |

**Parts ordering notes**

| Part no. | Designation | Quantity |
|---|---|---|
| 000 986 06 50 | Priming stick | 1 |
| 000 986 33 70 10 | Wax preservative | 1 |